



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18510
Job Sheet 194131



Part No: RBT18510

Job Qty: 1 pcs

Part Name: Bell 206A/B Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Due Date: 10/16/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBT18510 Rev.L IPP Rev. A 19.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - Issue SN	1 pcs	10/16/19	10/16/19	0.00	0.00	Small Fab - 2		MLL
100	Small Fab - 1	1 pcs	10/16/19	10/16/19	0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 2 - B4B		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	10/16/19	10/16/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-2 - Stock - B4B	1 pcs	10/16/19	10/16/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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CANADA
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Email: sales@dartaero.com
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Container No: S221151



Part: RBT18510

Job No: 194131

Serial No/Batch: S221151

Revision: L

Inspector:

Exp Date:

Instructions:

Date: 10/09/19

DAS
40

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	10/16/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS

21

OCT 10 2019

9-59

Part Op 95 - Issue S/N

Descriptions: 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-im3200-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per drawing sheet 3. 6-Place -7 and -8 placard in case as per drawing sheet 2.

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	95-Small Fab - Issue SN	5206761
APP-IM3200-E	Pelican Case RB Floor Left	1 Ea (1 ea)	100-Small Fab - 1	5187682
37 EE-1-901	Sling	2 Ea (2 ea)	100-Small Fab - 1	5163119
45 GOEX10B	Main Rotor Pillow Block Nut Wrench	1 Ea (1 ea)	100-Small Fab - 1	5150494
144 IN-050M	Linear Scale	1 Ea (1 ea)	100-Small Fab - 1	5193256
44 J7334	Deep Impact Socket, 1-1/16" X 12 Point X 1/2" Drive	1 Ea (1 ea)	100-Small Fab - 1	5165078
76 RB DB3182-19	Main Transmission Drain Tool Quill Assembly	1 pcs (1 ea)	100-Small Fab - 1	5219865
75 RB DB3182-23	Main Transmission Drain Tool Hose Assembly	1 pcs (1 ea)	100-Small Fab - 1	5192336
76 RB DB3225C-17	Free Wheeling Clutch Drain Tool Quill Assembly	1 pcs (1 ea)	100-Small Fab - 1	5197058
76 RB DB3225C-19	Free Wheeling Clutch Drain Tool Hose Assembly	1 pcs (1 ea)	100-Small Fab - 1	5165463
75 RB DB3225L-13	T/R Gearbox and Freewheeling Packaging Assembly	1 pcs (1 ea)	100-Small Fab - 1	5169523
80 RB DB3225L-15	T/R Gearbox and Freewheeling Hose Assembly	1 pcs (1 ea)	100-Small Fab - 1	5164517
151A RB23003267E	Power Turbine Support Cleaning C-18, C-20 & C-28	1 pcs (1 ea)	100-Small Fab - 1	5028341
139D RB23007638	Fuel Injector Wrench	1 pcs (1 ea)	100-Small Fab - 1	5219294
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 1	5021040
141D RB6796941-14	Starter Seal Guide	1 pcs (1 ea)	100-Small Fab - 1	5102895
141D RB6796941-18	Punch	1 pcs (1 ea)	100-Small Fab - 1	5103910
141D RB6796941-201	Puller Assembly/Starter Seal Removal Tool	1 pcs (1 ea)	100-Small Fab - 1	5207666
141D RB6796941-203P	SLIDE HAMMER ASSEMBLY	1 pcs (1 ea)	100-Small Fab - 1	5082704
139A RB6798292E	Wrench Ground Idle Screw Adjusting (Hinged)	1 pcs (1 ea)	100-Small Fab - 1	5RB4219-08
139B RB6798292-BP	Hinged Wrench with 5/16 Box End Fuel Control Removal	1 pcs (1 ea)	100-Small Fab - 1	5RB4230-17
139E RB877206-5-16P	Swashplate Bearing Install/Removal Set ?	1 pcs (1 ea)	100-Small Fab - 1	5028448
RBBP-1404-1	K-Flex Drive Shaft Tool	1 pcs (1 ea)	100-Small Fab - 1	5221110
141E RBE2-10-1	Fuel System Cartridge Removal Tool	1 pcs (1 ea)	100-Small Fab - 1	5157201
137 RBGTMD12p	drive shaft nut & M/R pillow bolt socket	1 pcs (1 ea)	100-Small Fab - 1	5028560
71 RBPA003-Ap	engine oil filter sump extractor	1 pcs (1 ea)	100-Small Fab - 1	5028574
71 RBPA003p	T/R drive shaft bearing lube tool	1 pcs (1 ea)	100-Small Fab - 1	5028573
137 RBSC7028-P	Portable Bearing Cutter ? RB001A	1 pcs (1 ea)	100-Small Fab - 1	5214436
138 RBST2812-P	Portable Tri-Roller Staking Tool	1 pcs (1 ea)	100-Small Fab - 1	5215545
145 RBT112800	Power Take Off Seal Installation Tool	1 pcs (1 ea)	100-Small Fab - 1	5102344
145A RBT18505p	T/R cross head puller-all 206 models	1 pcs (1 ea)	100-Small Fab - 1	5028589
145A RBT18506	Mast Nut Socket	1 pcs (1 ea)	100-Small Fab - 1	5166241
RBT18510-2	Bottom Foam use in case APP-IM3200-E	1 Ea (1 ea)	100-Small Fab - 1	5187670
252 RBT18510-3	Stiffener Assembly	1 pcs (1 ea)	100-Small Fab - 1	5215055
RBT18510-5	Top Foam use in case APP-IM3200-E	1 Ea (1 ea)	100-Small Fab - 1	5187671
RBT18510-6	Top Foam Cushion use in case APP-IM3200-E	1 Ea (1 ea)	100-Small Fab - 1	5187681
151B RBT18510-7	Top Shelf Placard	1 pcs (1 ea)	100-Small Fab - 1	5180947
151B RBT18510-8	Bottom Shelf Placard	1 pcs (1 ea)	100-Small Fab - 1	5181043
145B RBT18524	Oil Sump Straightening Tool	1 pcs (1 ea)	100-Small Fab - 1	5211670
145 RBT18538	Pilot, Co-Pilot Seat Brace	1 pcs (1 ea)	100-Small Fab - 1	5163999
145B RBT18539p	Helicopter Lifting Eye	1 pcs (1 ea)	100-Small Fab - 1	5014399-P-09
RBT18551	Swashplate Shim Bolts	1 pcs (1 ea)	100-Small Fab - 1	5221106
145B RBT18560	Engine Gearbox Seal Puller	1 pcs (1 ea)	100-Small Fab - 1	5211749
145A RBT18666p	main rotor restraint (206)	1 pcs (1 ea)	100-Small Fab - 1	5014817-U-13
97F RBT18717p	compressor case wrench set	1 pcs (1 ea)	100-Small Fab - 1	5028058
150B RBT200078	Trunnion Bearing Removal & Install Work Aid	1 pcs (1 ea)	100-Small Fab - 1	5159388
135A RBT400202	Bender Assembly	1 pcs (1 ea)	100-Small Fab - 1	5216618
136 RBT400203	Gage Assembly	1 pcs (1 ea)	100-Small Fab - 1	5194644
151F RBW109-3101-58-1	Hammer, Steel, Blade Corrosion and Voids Detection	1 pcs (1 ea)	100-Small Fab - 1	5199960
	RBW109-3101-58-2 Hammer, Aluminum, Blade Corrosion & Voids Detection	1 pcs (1 ea)	100-Small Fab - 1	5199962

-PO

012343

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - Issue SN	97524A032	4	265	0
	APP-IM3200-E	1	4	0
100-Small Fab - 1	EE-1-901	2	4	0
	GOEX10B	1	8	0
	IN-050M	1	5	0
	J7334	1	4	0
	RB DB3182-19	1	6	0
	RB DB3182-23	1	5	0
	RB DB3225C-17	1	12	0
	RB DB3225C-19	1	3	0
	RB DB3225L-13	1	3	0
	RB DB3225L-15	1	5	0
	RB23003267E	1	1	0
	RB23007638	1	10	0
	RB41011	1	193	0
	RB6796941-14	1	9	0
	RB6796941-18	1	4	0
	RB6796941-201	1	4	0
	RB6796941-203P	1	7	0
	RB6798292	1	1	0
	RB6798292-BP	1	10	0
	RB877206-5-16P	1	4	0
	RBBP-1404-1	1	1	0
	RBE2-10-1	1	8	0
	RBGTMD12p	1	3	0
	RBPA003-Ap	1	2	0
	RBPA003p	1	3	0
	RBSC7028-P	1	2	0
	RBST2812-P	1	1	0
	RBT112800	1	28	0
	RBT18505p	1	1	0
	RBT18506	1	2	0
	RBT18510-2	1	4	0
	RBT18510-3	1	4	0
	RBT18510-5	1	4	0
	RBT18510-6	1	4	0
	RBT18510-7	1	4	0
	RBT18510-8	1	4	0
	RBT18524	1	3	0
	RBT18538	1	8	0
	RBT18539p	1	3	0
	RBT18551	1	1	0
	RBT18560	1	4	0
	RBT18666p	1	1	0
	RBT18717p	1	3	0
	RBT200078	1	4	0
	RBT400202	1	4	0
	RBT400203	1	3	0
	RBW109-3101-58-1	1	2	0
	RBW109-3101-58-2	1	4	0

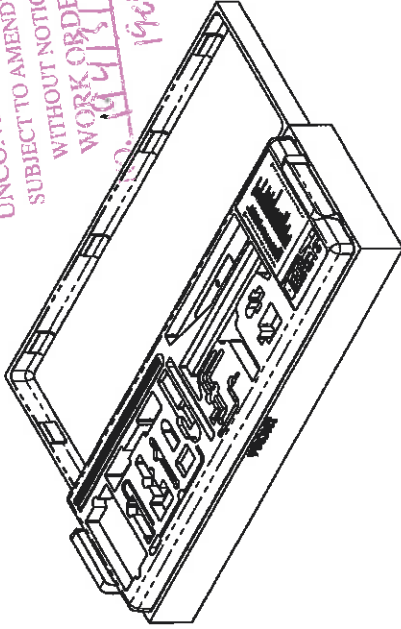
Part Specifications

Specifications could not be found.

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SHOP COPY
RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
194826



RBT18510 JET RANGER FIELD KIT

SEE PREVIOUS REVISION FOR MORE INFORMATION

UPDATED DRAWING TEMPLATE

UPDATED BOM TO REFERENCE CORRECT TOOL NUMBERS INCLUDED IN KIT

ITEM -2 WAS ITEM -87
ITEM -4 WAS ITEM -79
ITEM -5 WAS ITEM -89
ITEM -8 WAS ITEM -81
ITEM -10 WAS ITEM -81
ITEM -11 WAS ITEM -83

ADDED ITEMS -1, -3, -6, -7, -9, -12
REMOVED ITEMS -71, -75, -77

ITEM -10 WAS PROTO #J334 IS PROTO #J7234
ITEM -11 WAS OLYMPIC PRODUCTS #EE-1-101 IS OEP SLING #EE-1-901
ITEM -12 WAS PELICAN #APP-1700-E IS PELICAN #APP-M3200-E

-2, -4 CHANGED FOAM LAYOUT

-4 MATERIAL WAS COROPLAST, BLACK IS 0881-T6 / 7075-T6
CHANGED DIMENSIONS FOR UPDATED PELICAN CASE. ADDED HOLES FOR HANDLES

19-532
KPT

REV. DESCRIPTION

ECN #

BY

DESIGN

DRAWN

CHECKED

MFG. APPR.

APPROVED

DATE 3/7/2019

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBT18510

REV. L

SHEET 1 OF 11

SCALE

NTS

JET RANGER FIELD KIT

COMP. BY DART AEROSPACE LTD

NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS DESIGNED

ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18510-1	PACKAGING ASSEMBLY
-7	1	RBT18510-7	TOP SHELF PLACARD
-8	1	RBT18510-8	BOTTOM SHELF PLACARD
-9	1	RBT18510-9	SNAP-ON #GOEX10B (5/16" 12-POINT X 5-3/4" LG. COMBINATION WRENCH)
-10	1	RBT18510-10	PROTO #J7334 (1-1/16" X 12-POINT X 1/2" DRIVE DEEP IMPACT SOCKET)
-11	2	RBT18510-11	OSP SLING #EE-1-801 (EYE TO EYE NYLON SLING 1" WD. X 4' LG.)
-12	1	RBT18510-12	AMETEK CHATILLON #IN-050M (LINEAR SCALE 50 LB. X 8 OZ.)
-13	1	RBT18510-13	MAIN TRANSMISSION DRAIN TOOL QUILT ASSEMBLY
-14	1	RBT18510-14	MAIN TRANSMISSION DRAIN TOOL HOSE ASSEMBLY
-15	1	RBT18510-15	FREE WHEELING CLUTCH DRAIN TOOL QUILT ASSEMBLY
-16	1	RBT18510-16	FREE WHEELING CLUTCH DRAIN TOOL HOSE ASSEMBLY
-17	1	RBT18510-17	T/R GEARBOX AND FREEWHEELING PACKAGING ASSY
-18	1	RBT18510-18	T/R GEARBOX AND FREEWHEELING HOSE ASSY
-19	1	RBT18510-19	POWER TURBINE CLEANING KIT
-20	1	RBT18510-20	WRENCH - FUEL INJECTOR
-21	1	RBT18510-21	GUIDE
-22	1	RBT18510-22	PUNCH
-23	1	RBT18510-23	STARTER PULLER ASSY.
-24	1	RBT18510-24	SLIDE HAMMER ASSY.
-25	1	RBT18510-25	WRENCH - GROUND IDLE SCREW
-26	1	RBT18510-26	WRENCH - GROUND IDLE SCREW
-27	1	RBT18510-27	BEARING CUTTER REMOVAL & INSTALLATION TOOL ASSY
-28	1	RBT18510-28	K-FLEX DRIVE SHAFT TOOL
-29	1	RBT18510-29	FUEL SYSTEM CARTRIDGE REMOVAL TOOL
-30	1	RBT18510-30	DRIVE SHAFT NUT & M/R PILLOW BLOCK BOLT SOCKET
-31	1	RBT18510-31	T/R DRIVE SHAFT BEARING LUBRICATION TOOL
-32	1	RBT18510-32	OIL SUCTION DEVICE
-33	1	RBT18510-33	PORTABLE BEARING CUTTER
-34	1	RBT18510-34	PORTABLE TRI-ROLLER SWAGING TOOL
-35	1	RBT18510-35	PTO SEAL INSTALL TOOL
-36	1	RBT18510-36	T/R CROSSHEAD PULLER
-37	1	RBT18510-37	M/R MAST NUT SOCKET
-38	1	RBT18510-38	OIL SUMP STRAIGHTENER
-39	1	RBT18510-39	SEAT FRAME SUPPORTS
-40	1	RBT18510-40	JET RANGER LIFTING EYE
-41	1	RBT18510-41	SWASHPLATE SHIM BOLT
-42	1	RBT18510-42	ENGINE/GEARBOX SEAL PULLER
-43	1	RBT18510-43	MAIN ROTOR RESTRAINT
-44	1	RBT18510-44	WRENCH SET, COMPRESSOR CASE
-45	1	RBT18510-45	TRUNION BEARING REMOVAL AND INSTALLATION WORK AID
-46	1	RBT18510-46	TRIM TAB BENDER
-47	1	RBT18510-47	TRIM TAB BENDING GAUGE
-48	1	RBT18510-48	HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION
-49	1	RBT18510-49	HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION
-50	1	RBT18510-50	DART PLACARD
-51	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS																																			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																
Date: _____	Sequence #: _____	QTY Affected: _____																																			
Description Work Order Deviation		Disposition																																			
		Completed By																																			
		Lead hand / Supervisor																																			
		QC / QA Coordinator																																			
Root Cause		FAULT CATEGORY																																			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		<table border="1"><tr><td>Pressure/Forced</td><td>Contamination</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Bending</td><td>Misaligned/off center</td><td>Folio/Program</td><td>Outside Tolerance</td></tr><tr><td>Crushing</td><td>BOM/Route</td><td>Grain Direction</td><td>Drawing</td></tr><tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Finish</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>Incomplete/Unclear Instructions</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Out of Sequence</td><td>Misread</td></tr><tr><td>Mislabeled</td><td>Fit/Function</td><td>Off-set/Set-up</td><td></td></tr><tr><td colspan="4">Other/Details:</td></tr></table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up		Other/Details:			
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